

Monday, September 12, 2016 10:29:56 AM

150926

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Item Name: Tail Rotor Pedal Lock

Start Date: 9/8/2016 **Start Qty:** 1.00 ***1***

Cust Item ID:

Required Date: 9/12/2016 **Req'd Qty:** 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: **DAS** Date: **SEP 12 2016**
21

Tooling:

Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

SPC (Y/N):

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3371	Rev B

0.00

120

120

Small Fab

0.23

Small Fab

Small Fab

Memo

ATTN: - CHECK IF KEYED ALIKE OR KEYED DIFFERENT1- Press dowel pins as per Dwg D3371, then assemble hinge.Ensure that assembly opens & closes smoothly. Identify as D3371-051.

2- Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.

3- Fabricate D3371-5 cam as per Dwg D3371. Identify as D3371-5

4- Assemble lock mechanism and cam and install decal as per Dwg D3371.

Apply locktite to lock body nut.

Qty	Part Number	Description
A/R		262 Locktite

Batch
M133046

0.00

130

130

Small Fab

0.10

Small Fab

Small Fab

Memo

Assemble lanyard to cyclic sock as per Dwg D3384
Identify as D3384-045

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Work Order ID 150926

Monday, September 12, 2016 10:29:56 AM

150926

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Item ID: D3371-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Tail Rotor Pedal Lock
Start Date: 9/8/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 9/12/2016 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.02							
Quality Control									

DAS
21
9-89 OCT 17 2016

DQA: _____ Date: _____



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Picklist Print

Monday, September 12, 2016 10:30:00 AM

Page 1

Work Order ID: 150926

150926

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: A Removed from 9 Digit 06-03-10 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
238-028 *238-028* 3/16" Dowel Pin .5" long		Purchased	No			120	Each	54.0000	2	2			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST578				54					SEP 30 2016
				M132062				54					
AN526C832R6 *AN526C832R6* Screw		Purchased	No			120	Each	92.0000	4	4			FF OCT 14 2016
				<u>Location</u>				<u>Loc Qty</u>					
				GA				92					
				m131379				92					
D2728-7 *D2728-7* Dart Logo Label		Manufactured	Yes			120	Each	0.0000	1	1			FF OCT 14 2016
D3371-1 *D3371-1* Pedal Lock Base		Manufactured	No			120	Each	7.0000	1	1			DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					SEP 30 2016
				ST498				7					
				139035				1					
				148601				6					

DQA: _____ Date: _____



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Picklist Print

Monday, September 12, 2016 10:30:00 AM

Page 2

Work Order ID: 150926

150926

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 1.00

Required Qty: 1.00

D3371-3 Manufactured No

120 Each 6.0000 1 1

D3371-3

Pedal Lock Cover

Location

Loc Qty

Loc Code

ST498

6

144752

6

SEP 30 2016

DAS
6
9-89

D3373-7 Manufactured No

120 Each 6.0000 1 1

D3373-7

Cam Lock

Location

Loc Qty

Loc Code

ST033

6

94791

6

SEP 30 2016

DAS
6
9-89

D3385-3 Manufactured No

120 Each 9.0000 1 1

D3385-3

Hinge

Location

Loc Qty

Loc Code

ST034

9

117534

9

SEP 30 2016

DAS
6
9-89

CBL-1240 Purchased No

130 f 251.7816 1.6666 1.754316

CBL-1240

Cable

Location

Loc Qty

Loc Code

GA

251.781644

m132518

251.781644

OCT 14 2016

1.754316

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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																								OTHER :																																							

Picklist Print

Monday, September 12, 2016 10:30:00 AM

Page 3

Work Order ID: 150926

150926

Parent Item: D3371-041

D3371-041

Parent Item Name: Tail Rotor Pedal Lock

Start Date: 9/8/2016

Required Date: 9/12/2016

Start Qty: 1.00

Required Qty: 1.00

CBL-460

Purchased

No

130

Each

156.0000

2

2

CBL-460

Loop Sleeve

FF

OCT 14 2016

Location

Loc Qty

Loc Code

GA

135858

156

2

m131619

5

m133344

10

m133786

5

m133875

4

m133985

5

m134385

5

m134592

7

m134688

21

mm135253

94

D3384-1

Manufactured

No

130

Each

6.0000

1

1

D3384-1

Cyclic Sock

SEP 30 2016

Location

Loc Qty

Loc Code

ST500

6

148602

6

HX-81

Purchased

No

140

Each

32.0000

1

1

HX-81

1/4"-20 SHCS 3/8" long

SEP 30 2016

Location

Loc Qty

Loc Code

ST563

32

123436

32

NAS1149F0463P

Purchased

No

140

Each

710.0000

2

2

NAS1149F0463P

Washer

SEP 30 2016

Location

Loc Qty

Loc Code

ST262

710

m127832

710

2

Monday, September 12, 2016 10:30:00 AM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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